



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-311
Job Sheet 183535



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No: NO-AIRBUS

Due Date: 10/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/24/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	1 pcs		10/24/18	0.00	0.99	Large Fab 2		SLU
120	QC	1 pcs		10/24/18	0.00	0.00	QC9		CPC
130	QC	1 pcs		10/24/18	0.00	0.00	QC5		CPC
140	HandFinish	1 pcs		10/24/18	0.00	0.18	HandFinish1		DR 18/09/25
150	QC	1 pcs		10/24/18	0.00	0.00	QC7-2		38
180	Large Fab	1 pcs		10/24/18	0.00	0.99	Large Fab 2		SLU
190	QC	1 pcs		10/24/18	0.00	0.00	QC10		38 DAS
200	QC	1 pcs		10/24/18	0.00	0.00	QC5		9-59 38
210	HandFinish	1 pcs		10/24/18	0.00	0.18	HandFinish1		DR 18/10/1
220	Powdercoat	1 pcs		10/24/18	0.00	0.29	Powdercoat1		BR 15-10-3
230	HandFinish	1 pcs		10/24/18	0.00	0.18	HandFinish3		BR 15-10-3
240	QC	1 pcs		10/24/18	0.00	0.00	QC3		OCT 09 2018 68
250	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging1-3		9-89
260	QC	1 pcs		10/24/18	0.00	0.00	QC4		68 DAS
270	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging3-1		69 DAS
275	DC	1 pcs		10/24/18	0.00	0.00	DC		21 OCT 11 2018
280	QC21-FG	1 Ea		10/24/18	0.00	0.00	QC21		3-59

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 1134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod

220 - START TIME: 2:15 OVEN TEMPERATURE: 320° FINISH TIME: 2:15

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	S104284
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	S104284
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	S104677

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition																					
				Completed By																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

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087 9410-011

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	119	0
	D3219-1	2	109	0
	D3272-1	1	1	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	74	0
	MS20600-AD4W4	16	284	0
250-Packaging	AN3-35A	2	395	0
	AN4-13A	8	786	0
	AN5-36A	2	338	0
	D2230-3	4	203	0
	D2618	2	187	0
	D2856-400-720	2	226	0
	D3235-1	2	30	0
	D3278-041	1	0	0
	MS21042L3	2	3,192	0
	MS21042L4	8	4,030	0
	MS21042L5	2	856	0
	NAS1149D0363J	4	2,169	0
	NAS1149D0463J	16	7,088	0
	NAS1149D0563J	4	1,620	0

058 9410-011

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Part Specifications

Specifications could not be found.

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		 Container No: S112372 Part: D350-591-311 Job No: 183535 Serial No/Batch: S112372 Revision: Inspector: Exp Date: Instructions: TC STC SH92-6 Issue 1dai FAbz STC SH967NE 04/12/21, BRAZIL 1																																																							
Date : _____ Step #: _____ Description Work Order Deviation 																																																											
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;">☐ Environment</td> <td style="width: 50%;">☐ No Re-verification</td> </tr> <tr> <td>☐ Design</td> <td>☐ Operator</td> </tr> <tr> <td>☐ Doc/Data</td> <td>☐ Offset/Setup</td> </tr> <tr> <td>☐ Equip/Tooling</td> <td>☐ Supplier</td> </tr> <tr> <td>☐ Handling/Pre</td> <td>☐ Training</td> </tr> <tr> <td>☐ Material</td> <td>☐ Use for Testing</td> </tr> <tr> <td>☐ Internal Transport</td> <td>☐ Poor Information</td> </tr> <tr> <td>☐ Tribal Knowledge</td> <td>☐ Rushing</td> </tr> <tr> <td>☐ LOA</td> <td>☐ Product Improvement</td> </tr> <tr> <td>☐ Substation</td> <td>☐ Process Improvement</td> </tr> <tr> <td>☐ Past Expiry Date</td> <td>☐ Manufacturing Process</td> </tr> <tr> <td>☐ Misidentified</td> <td>☐ Past Due</td> </tr> </table>		☐ Environment	☐ No Re-verification	☐ Design	☐ Operator	☐ Doc/Data	☐ Offset/Setup	☐ Equip/Tooling	☐ Supplier	☐ Handling/Pre	☐ Training	☐ Material	☐ Use for Testing	☐ Internal Transport	☐ Poor Information	☐ Tribal Knowledge	☐ Rushing	☐ LOA	☐ Product Improvement	☐ Substation	☐ Process Improvement	☐ Past Expiry Date	☐ Manufacturing Process	☐ Misidentified	☐ Past Due	FAULT CATEGORY <table style="width: 100%;"> <tr> <td style="width: 33%;">☐ Pressure/Forced</td> <td style="width: 33%;">☐ Temperature/Cure</td> <td style="width: 33%;">☐ Power Loss/Surge</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> </tr> <tr> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mis-labeled</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> </tr> </table>				☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Crushing	☐ Countersink	☐ Off-set	☐ Heat Treat	☐ Cut Too Short	☐ Mis-labeled	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center
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D350-591-311
Job Sheet 183535



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No: NO-AIRBUS

Due Date: 10/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/24/18	0.00	0.00	Start Up Large Fab-4		SLC
110	Large Fab	1 pcs		10/24/18	0.00	0.99	Large Fab 2		SLC
120	QC	1 pcs		10/24/18	0.00	0.00	QC9		CPC
130	QC	1 pcs		10/24/18	0.00	0.00	QC5		CPC
140	HandFinish	1 pcs		10/24/18	0.00	0.18	HandFinish1		DR 18/09/25
150	QC	1 pcs		10/24/18	0.00	0.00	QC7-2		
180	Large Fab	1 pcs		10/24/18	0.00	0.99	Large Fab 2		SLC
190	QC	1 pcs		10/24/18	0.00	0.00	QC10		
200	QC	1 pcs		10/24/18	0.00	0.00	QC5		
210	HandFinish	1 pcs		10/24/18	0.00	0.18	HandFinish1		
220	Powdercoat	1 pcs		10/24/18	0.00	0.29	Powdercoat1		
230	HandFinish	1 pcs		10/24/18	0.00	0.18	HandFinish3		
240	QC	1 pcs		10/24/18	0.00	0.00	QC3		
250	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		10/24/18	0.00	0.00	QC4		
270	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		10/24/18	0.00	0.00	DC		
280	QC21-FG	1 Ea		10/24/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084
275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	SLC
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	SLC
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	SLC

D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

DSI 9410-011

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5113205
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5083541
5095293
5089299
5093773
5103492

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	119	0
	D3219-1	2	109	0
	D3272-1	1	1	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	74	0
250-Packaging	MS20600-AD4W4	16	284	0
	AN3-35A	2	395	0
	AN4-13A	8	786	0
	AN5-36A	2	338	0
	D2230-3	4	203	0
	D2618	2	187	0
	D2856-400-720	2	226	0
	D3235-1	2	30	0
	D3278-041	1	0	0
	MS21042L3	2	3,192	0
	MS21042L4	8	4,030	0
	MS21042L5	2	856	0
	NAS1149D0363J	4	2,169	0
	NAS1149D0463J	16	7,088	0
	NAS1149D0563J	4	1,620	0

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Part Specifications

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ini

Specifications could not be found.

005584

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]